

Date: 17/08/2007 11:21:00 AM  
User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34080 -1  
Estimate Number : 12304  
P.O. Number : *N/A*  
This Issue : 17/08/2007 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : SMALL /MED FAB  
Previous Run : 32039  
Written By : *[Signature]*  
Checked & Approved By : *[Signature]*  
Comment : Est Rev. A New Issue 06-04-24 EC  
Est Rev:B As per Rev B 06-05-24 JLM

Drawing Name : AFT PLATE ASSEMBLY  
Part Number : D3467045  
Drawing Number : D3467 REV B  
Project Number : N/A  
Drawing Revision : B  
Material : *N/A*  
Due Date : 11/09/2007  
Qty: *3* / Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3467049	BAFFLE & DEFLECTOR ASSEMBLY

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-49	Baffle ass'y	<i>B34092 x 3 mx, B34490 x 1 mx.</i>

*mf*

2.0	D34673	TUBE
-----	--------	------

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3467-3	Tube	<i>B34099 x 8mx, B34490 x 1mx.</i>

*mf*

3.0	D34675	AFT PLATE
-----	--------	-----------

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-5	aft plate	<i>B34100.</i>

*mf*

4.0	D346711	BRACKET
-----	---------	---------

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:




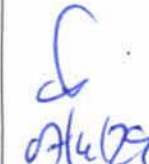
Qty	Part Number	Description	Batch
2	D3467-11	Bracket	<i>B34094 x 2mx, B34094 x 6mx,</i>

*mf**07-10-15**(PTC)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/23 <del>07/10</del>	9	Split W/O	SS	07/10/23	3		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 07/14/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10- 15	9	- spot weld hole through doubler.  P 3467-20 # B32048	 07.11.29	added doubler on top.	07-10- 15. mf.	 Hulzen	07.11.29 	 07/11/29

NOTE: Date & initial all entries



Date: Friday, 17/08/2007 11:21:00 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT PLATE ASSEMBLY

Job Number: 34080

Part Number: D3467045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D346717

TOP COVER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3467-17 Shourd Plate

Batch

B34095 x 4mx

mf

6.0

D346719

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3467-19 Doubler

Batch

B34096 x 4mx

mf

7.0

D346720

doubler RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3467-20 Doubler

Batch

B34098 x 4mx, B32048 x 1mx

mf

8.0

NAS1031C3W

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nutplate

m105728

mf

07-10-15

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-045

mf 07-10-15

PTD  
hont page



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:00 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT PLATE ASSEMBLY

Job Number: 34080

Part Number: D3467045

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/11/29 (3)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 07/11/29 (X3)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 158

W

AS 07/11/30

(3)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 07/11/30 (3)

Job Completion



W 07/11/30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

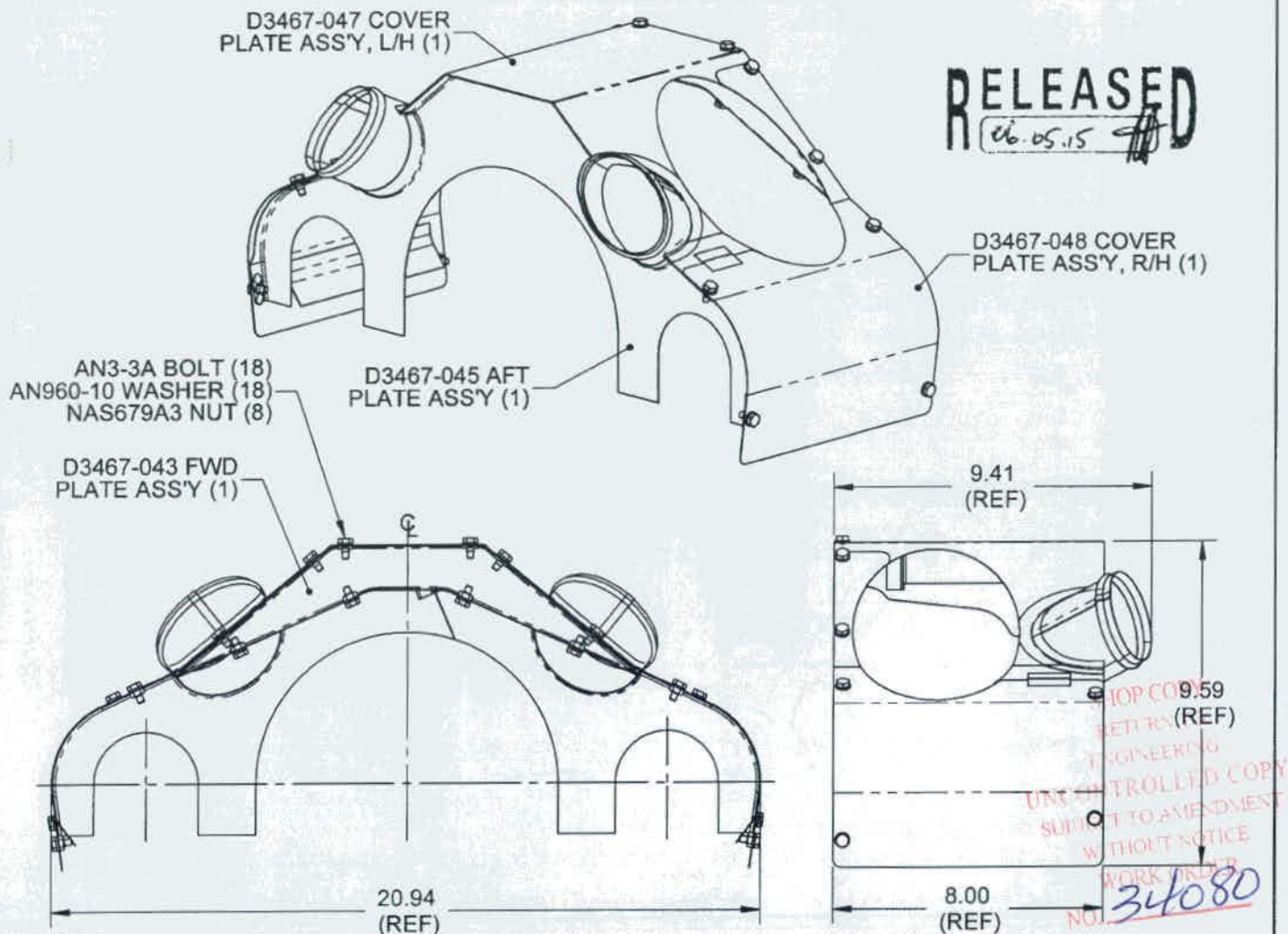
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3467</b>	REV. B SHEET 1 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	$\phi 0.250$ & $\phi 0.203$ WERE $\phi 0.194$ ; UPDATED D3467-9F/-15F	

**D3467-041 SHROUD ASSEMBLY****NOTES:**

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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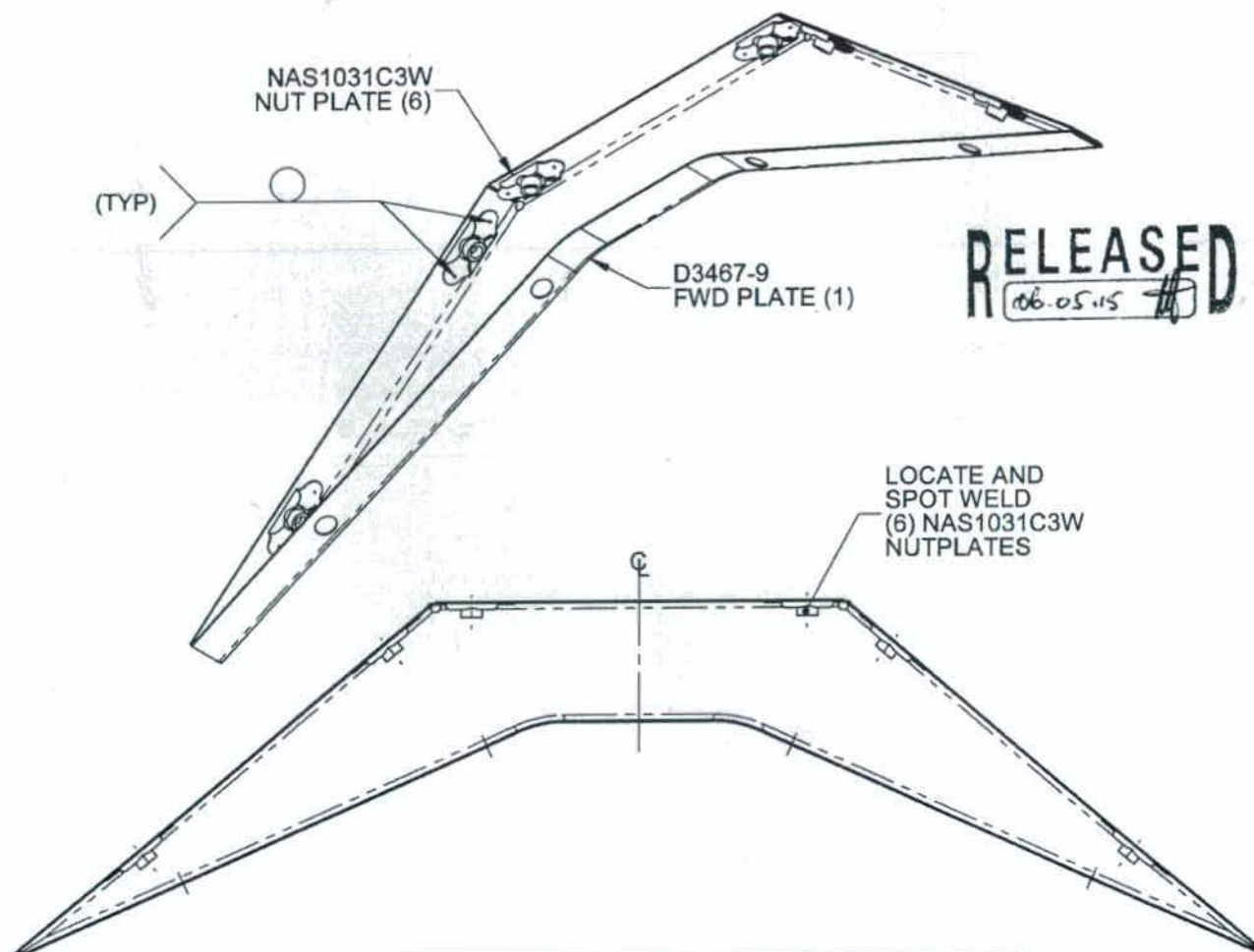
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

**D3467-043 FWD PLATE ASSEMBLY****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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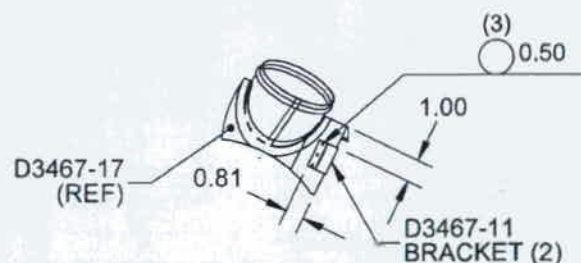
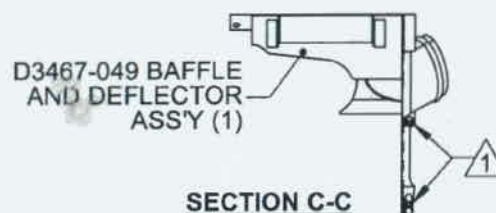
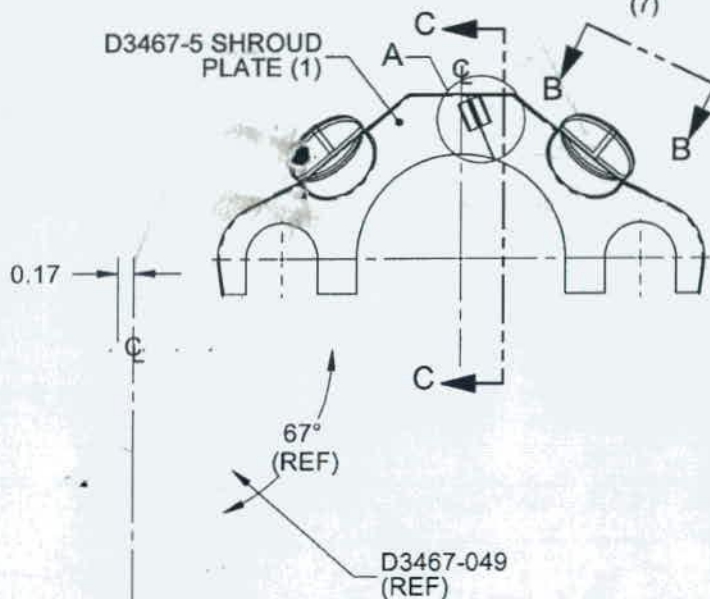
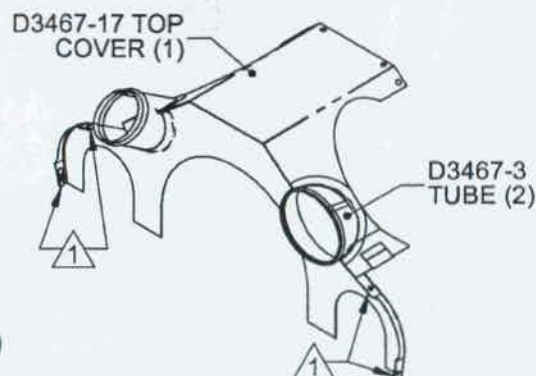
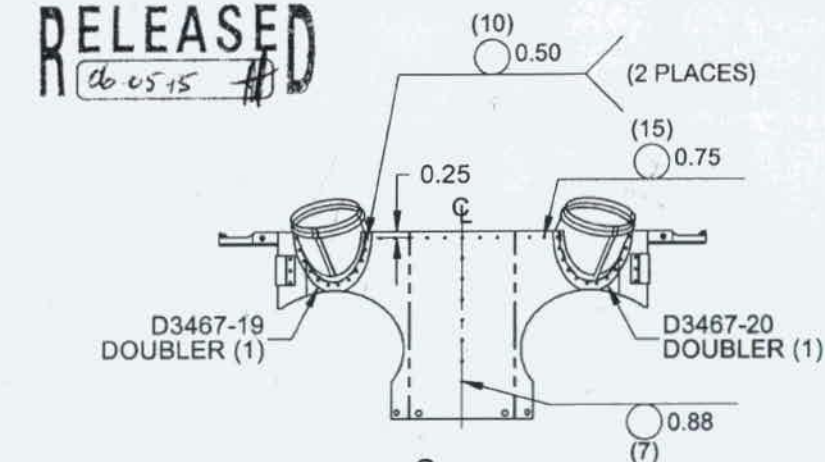
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DATE <b>06.05.15</b>	TITLE <b>SHROUD ASSEMBLY</b>		SCALE 1:8

**RELEASED**  
06.05.15

**VIEW B-B: WELDING D3467-11**  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)

**DETAIL A**  
SCALE 1:2

### D3467-045 AFT PLATE ASSEMBLY

#### NOTES:

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

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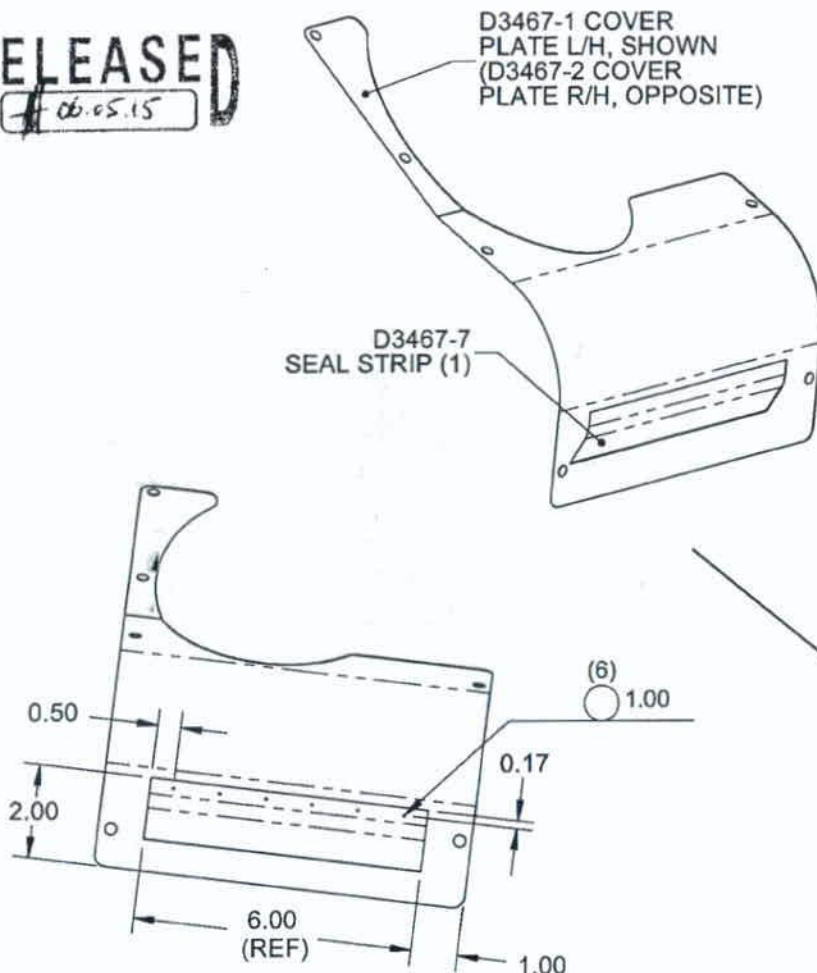
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**RELEASED**  
06.05.15

**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

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**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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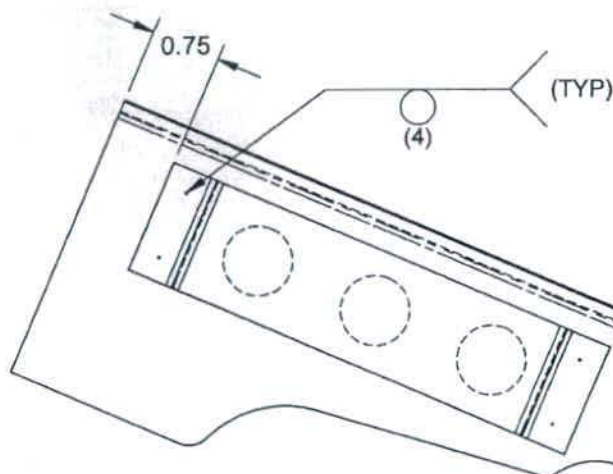
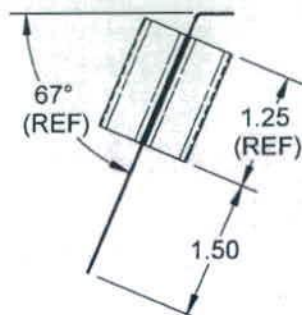
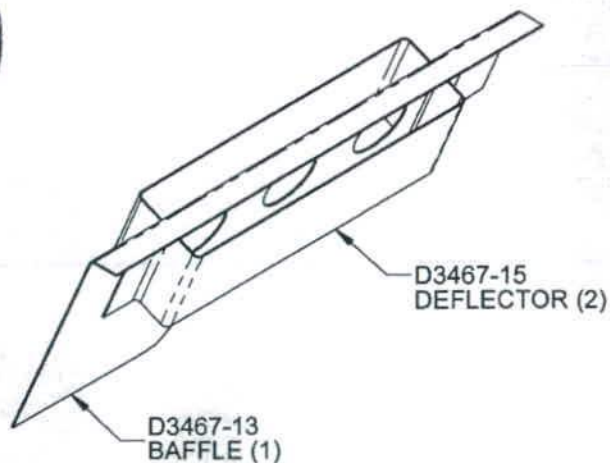
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
13 06.05.15**D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -049	P/N	DESCRIPTION
	<b>D3467-049</b>	<b>BAFFLE &amp; DEFLECTOR ASSEMBLY</b>
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

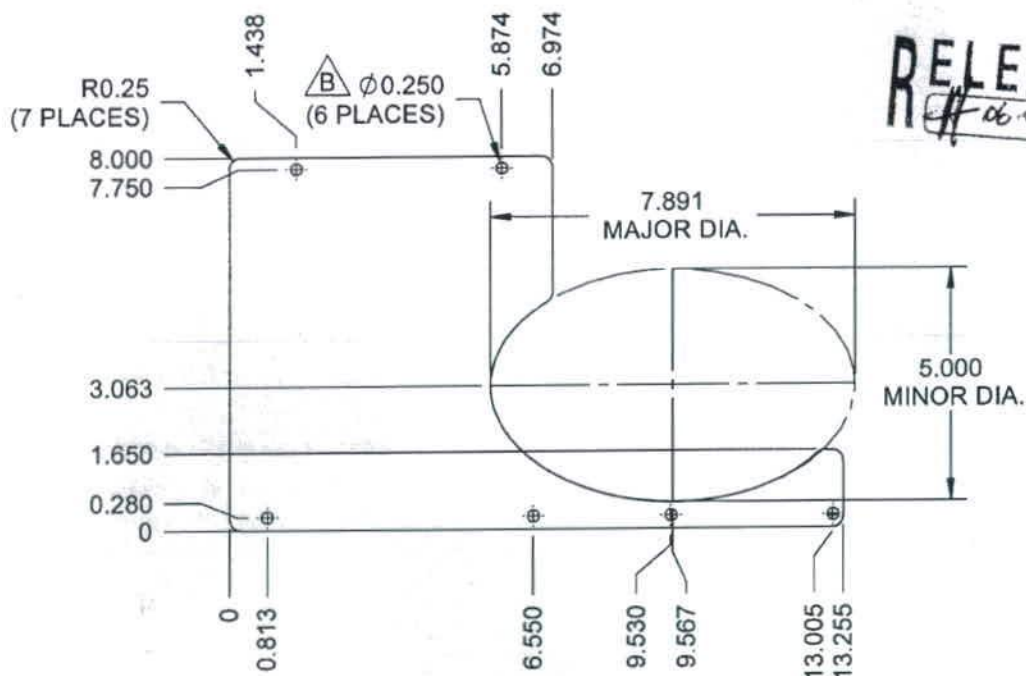
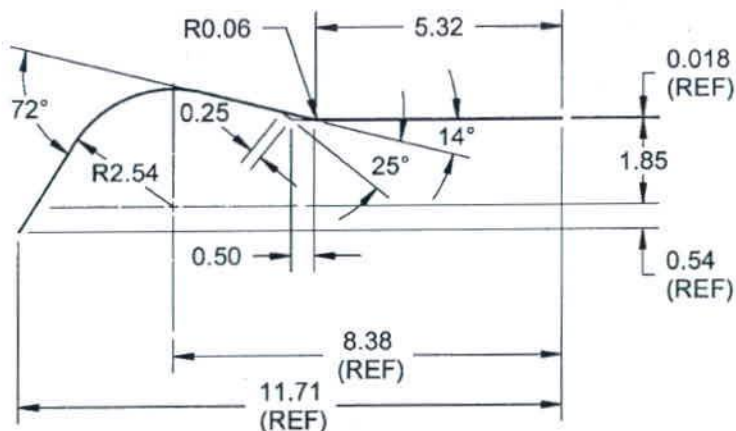
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CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 6 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER  
PLATE ISOMETRIC VIEW.**  
**D3467-2 R/H COVER  
PLATE (OPPOSITE)**  
SCALE 1:8**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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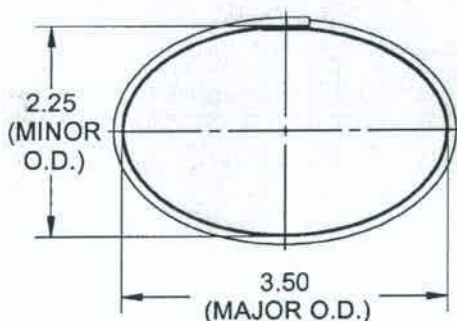
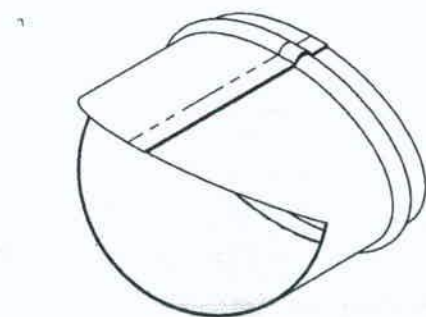
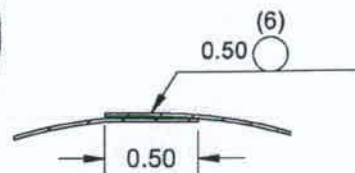
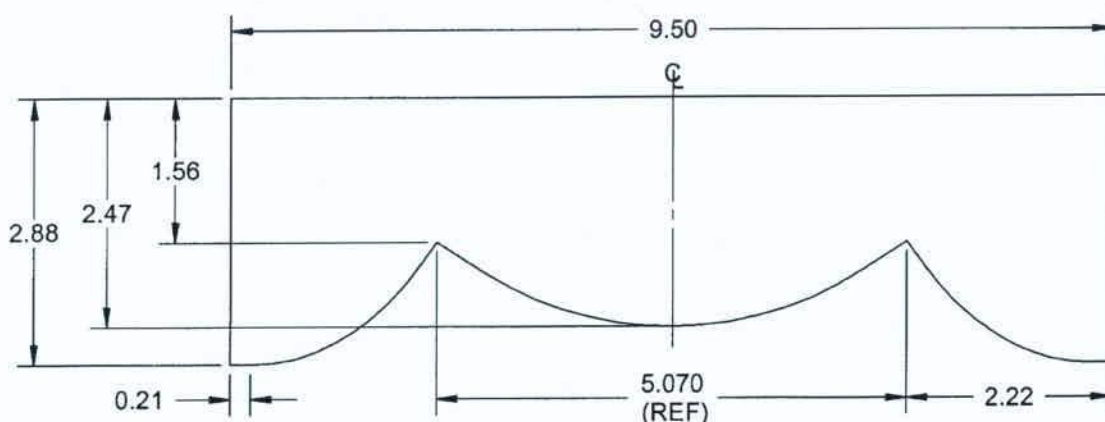
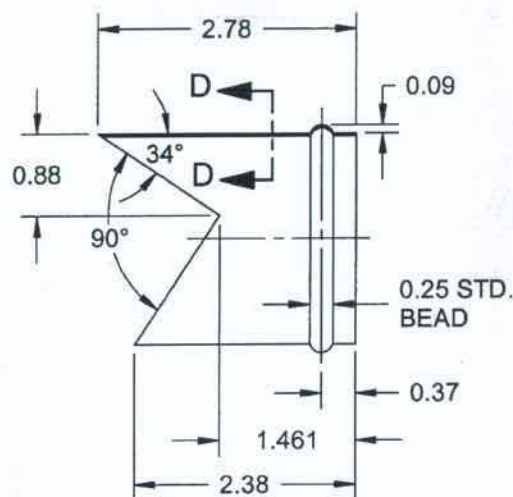
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CHECKED H	APPROVED H	DRAWING NO. <b>D3467</b>	REV. B SHEET 7 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
# 06.05.15**D3467-3 TUBE DETAIL****SECTION D-D**  
SCALE 1:1**D3467-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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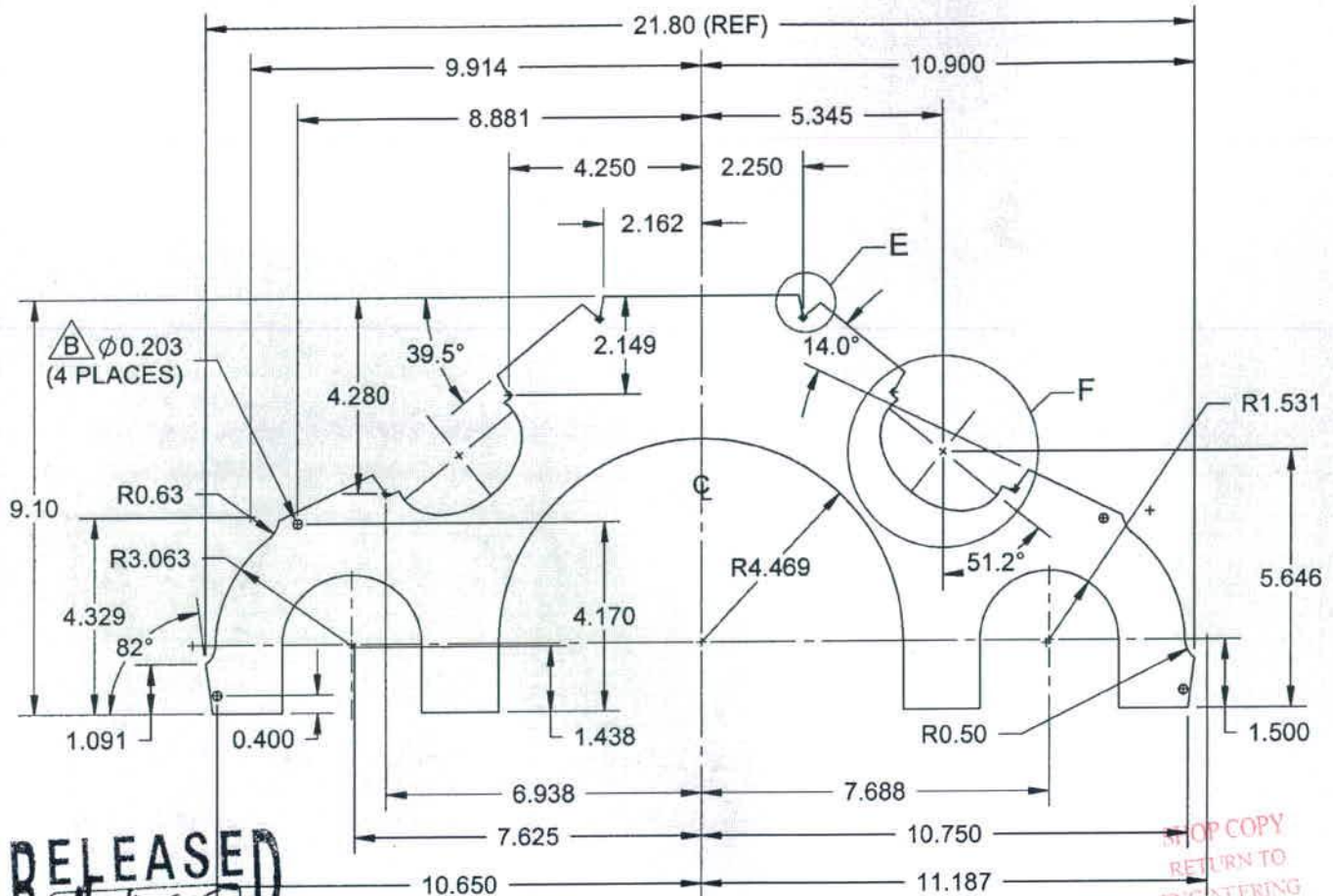
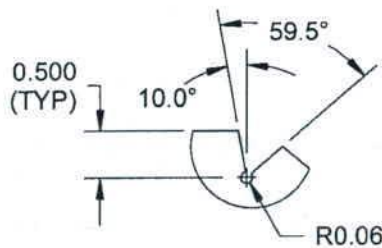
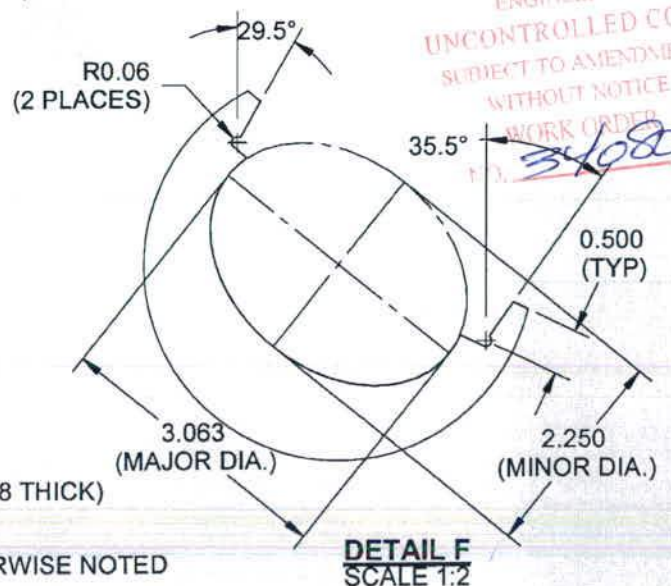
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 8 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8

**RELEASED**  
# 06-05-15**DETAIL E**  
SCALE 1:2**DETAIL F**  
SCALE 1:2**D3467-5F AFT PLATE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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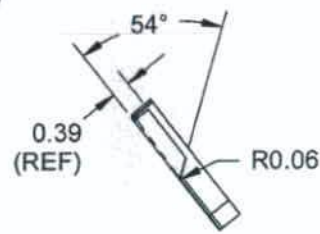
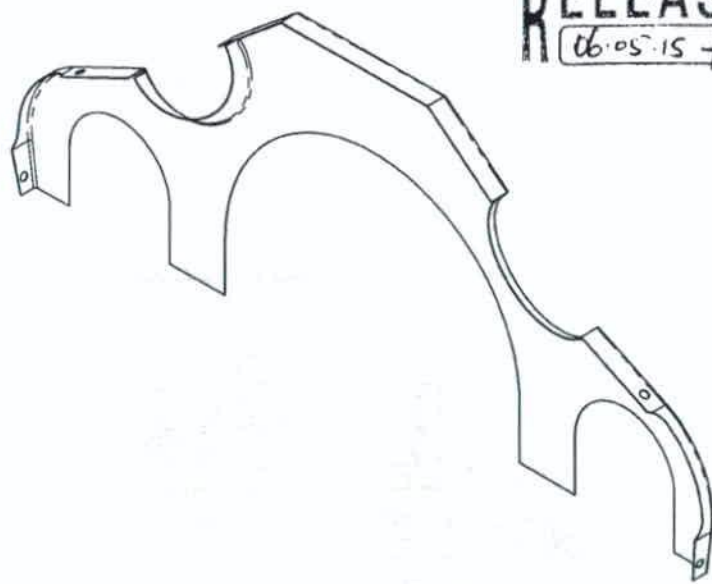
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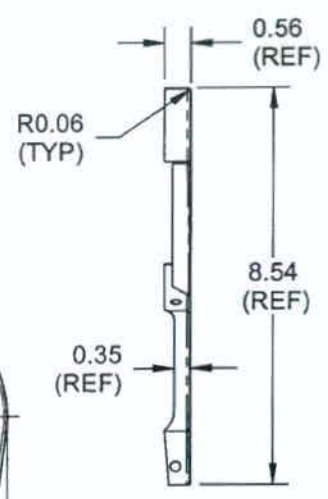
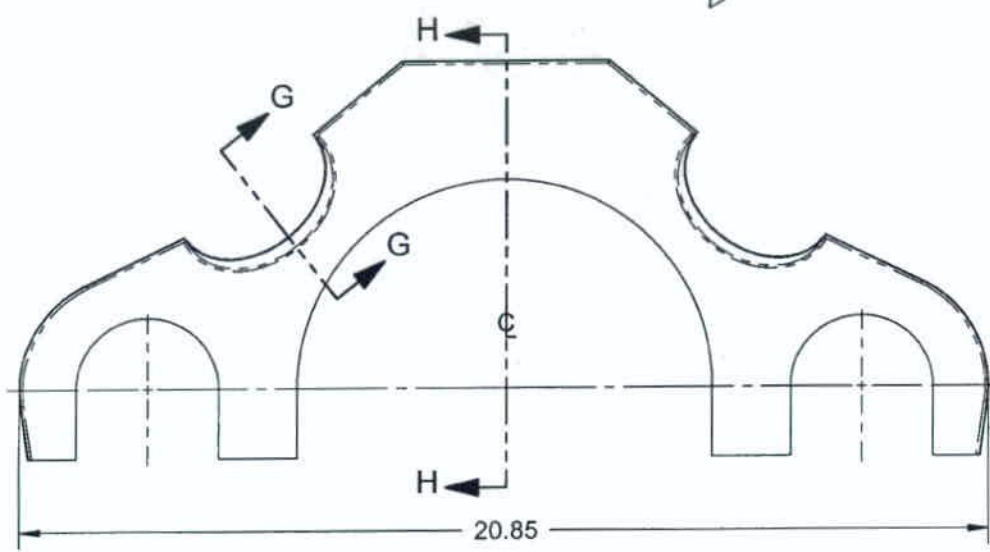


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CHECKED H	APPROVED H	DRAWING NO. D3467	REV. B SHEET 9 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

RELEASED  
06.05.15



**SECTION G-G**



**SECTION H-H**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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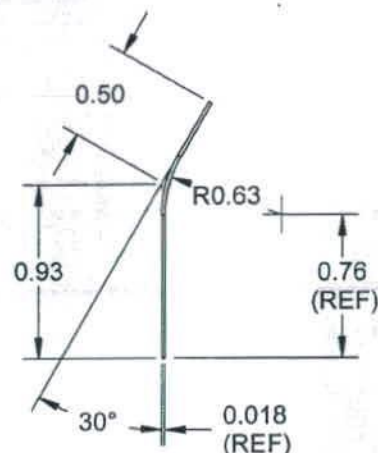


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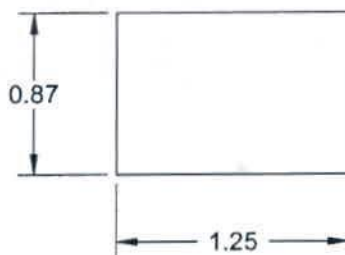
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:1

**RELEASED**  
06.05.15

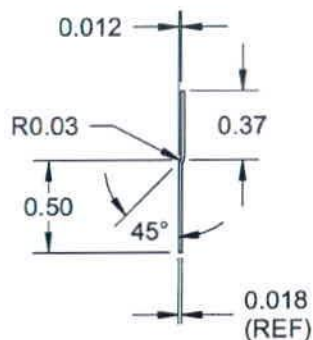
**D3467-7F SEAL STRIP  
FLAT PATTERN**



**D3467-7 SEAL STRIP  
BENDING DETAIL**



**D3467-11F BRACKET  
FLAT PATTERN**



**D3467-11 BRACKET  
JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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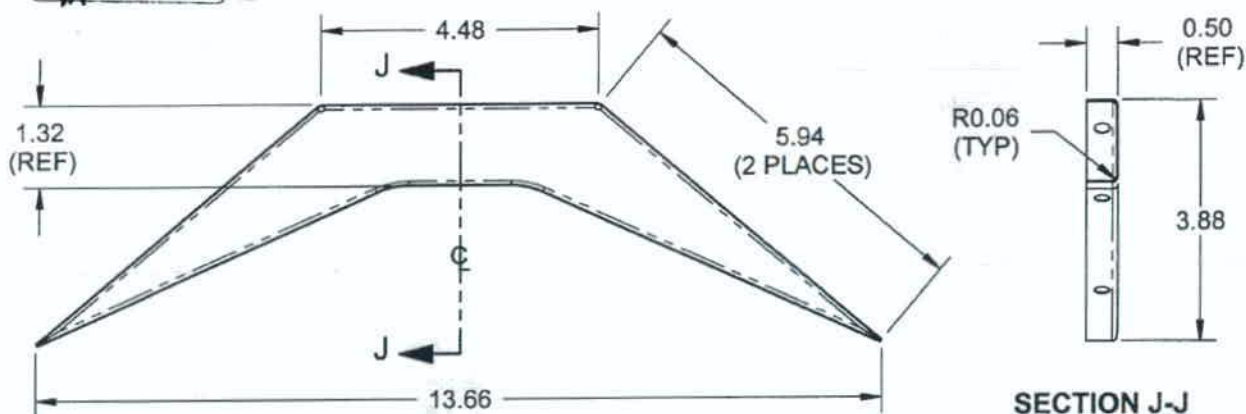




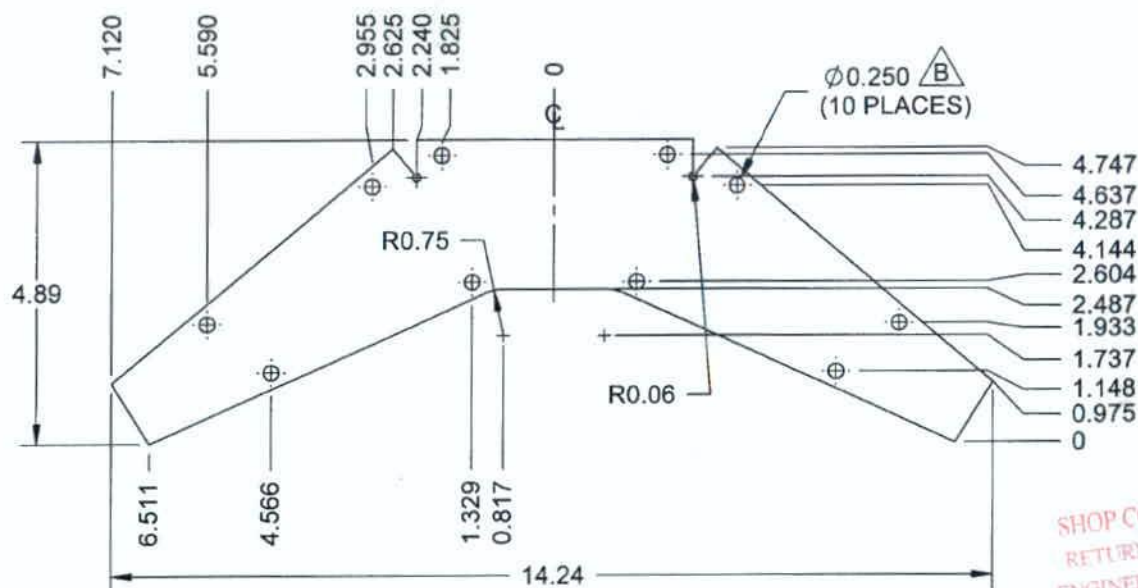


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DATE <b>06.05.15</b>	TITLE <b>SHROUD ASSEMBLY</b>	REV. B SHEET 11 OF 15 SCALE 1:3

**RELEASED**  
*06.05.15*



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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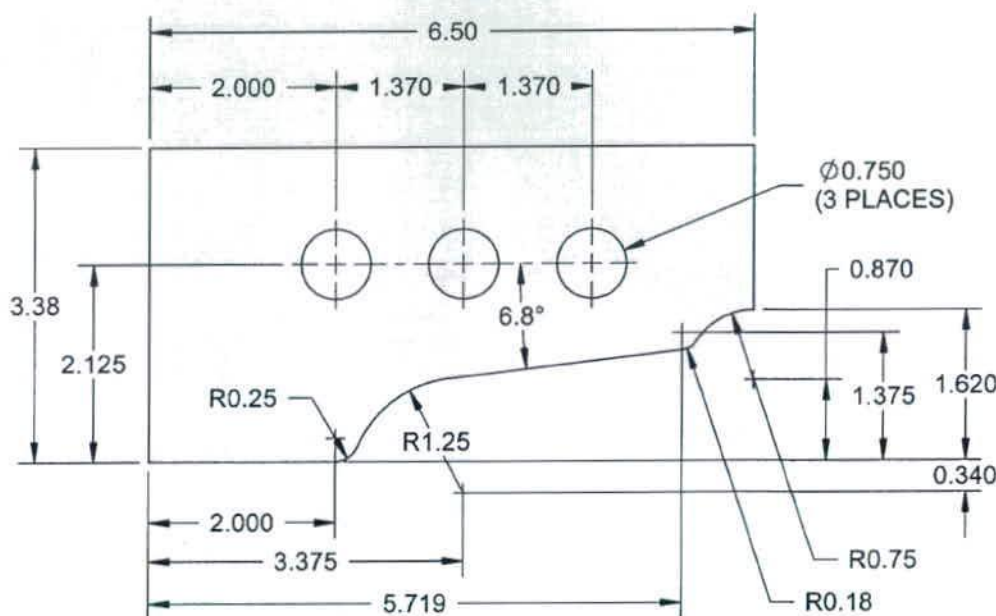
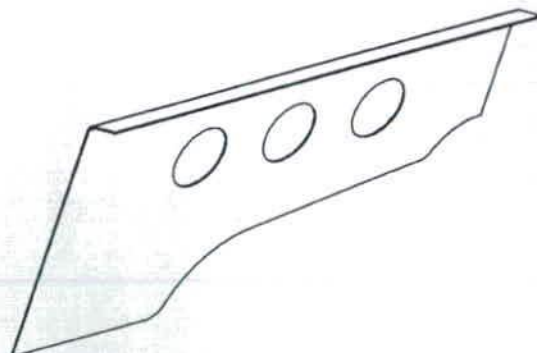
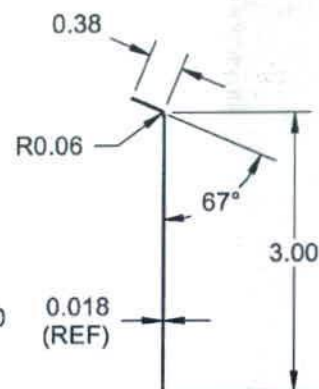
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

**RELEASED**  
*# 06-05-15***D3467-13F BAFFLE  
FLAT PATTERN****D3467-13 BAFFLE  
BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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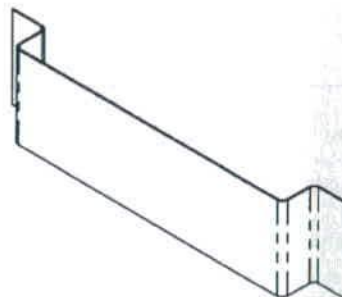
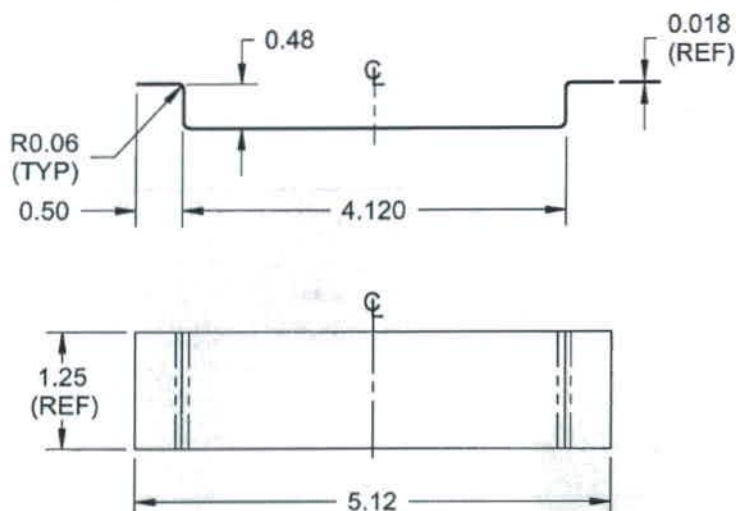
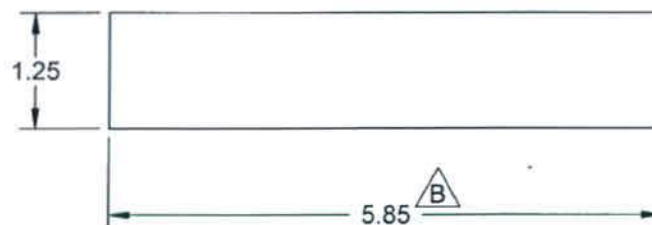
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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

**RELEASED**  
*[Stamp]***D3467-15 DEFLECTOR BENDING DETAIL****D3467-15F DEFLECTOR FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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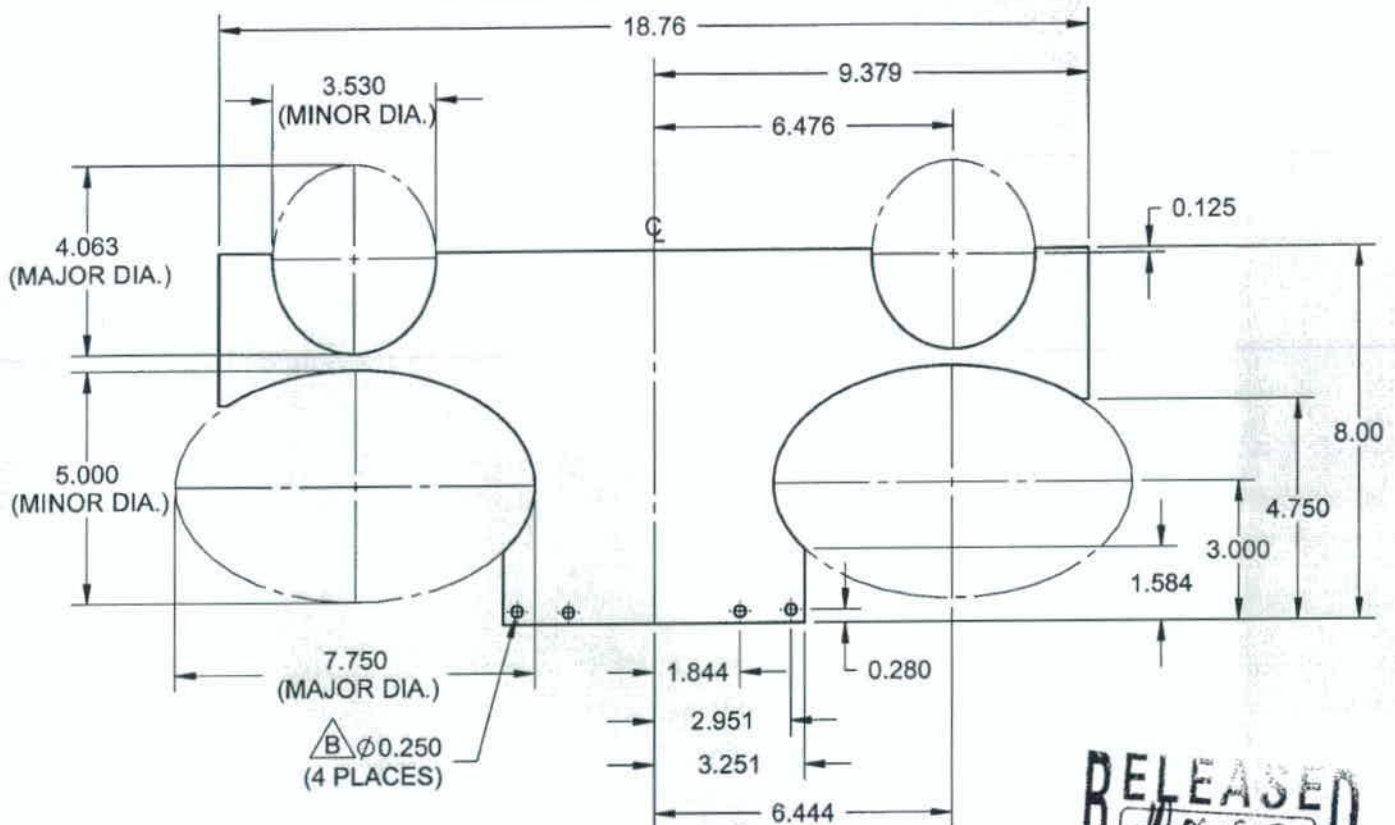
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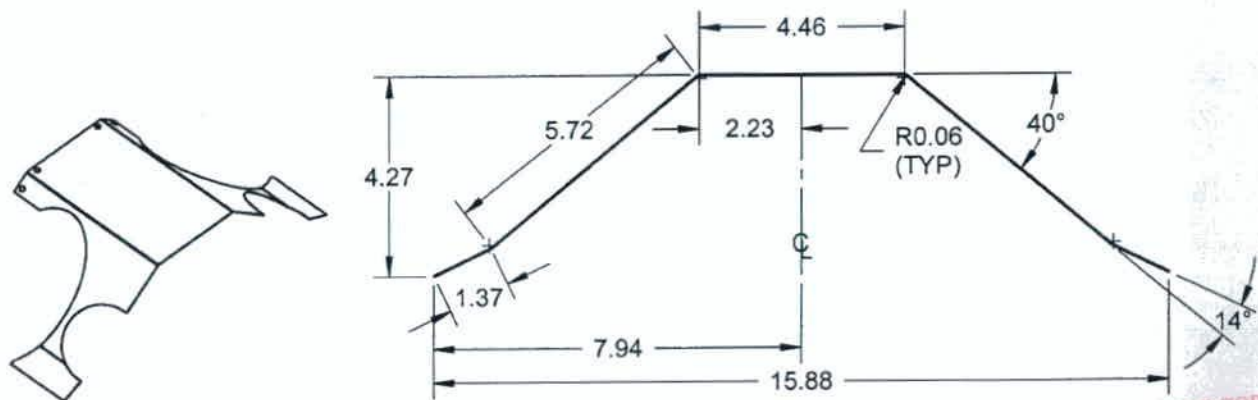




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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4



**D3467-17F TOP COVER FLAT PATTERN**



**D3467-17 TOP COVER BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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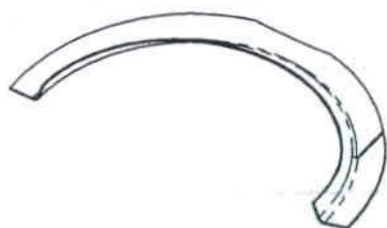
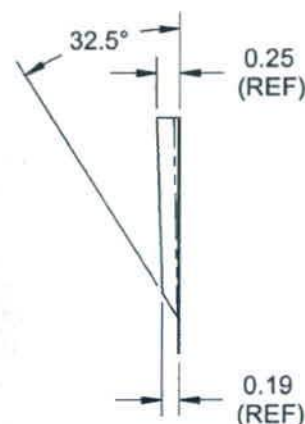
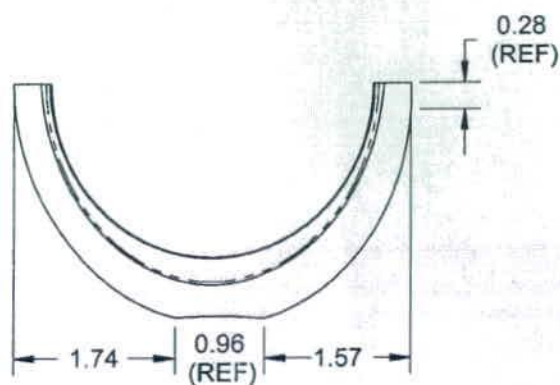
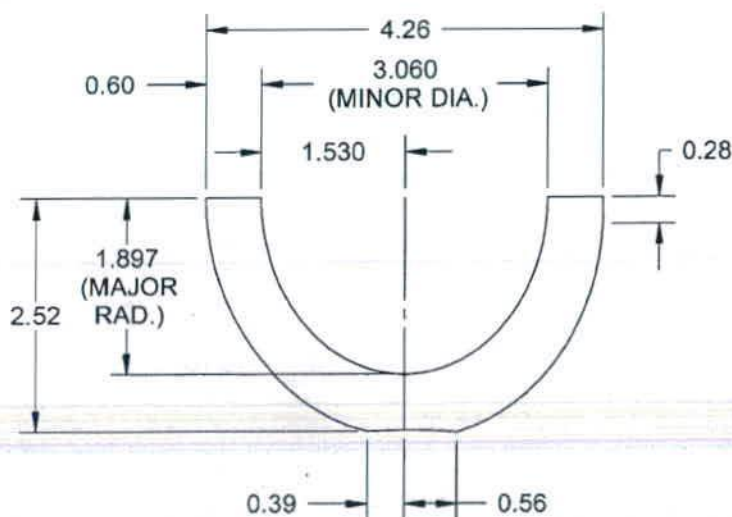
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
13 06 vs 15**DETAIL K**  
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**

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**D3467-19F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD  
AMS-W-6858A  
CLASS 'C'

TEST NO#: 25

EMPLOYEE: Melanie Fauter

PART NUMBER: D3467-045

JOB NUMBER: B34080

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/10/17  
QUALIFIER: SB

